

54548 OREC

Work Order ID 52448



Page 1

Friday, September 25, 2009 10:59:40 AM

Item ID: D3110-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Escutcheon

Start Date: 9/25/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/5/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*Date: *09-25*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3110

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 6.400" x 1.25" x .25" thick
Note: 1 blank makes 2 parts*grl 09/10/11**8**0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA215

*L.A 09/10/11**8**0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*L.A 09/10/11**8**0*

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Page 2

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Setup Start

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Stop

Item Name: Escutcheon

Start Date: 9/25/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 10/5/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 09/10/11

8

0

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Tumble or Deburr Polish to a high lustre!

SB 09/12/09

0

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/12/11

(8x50)

Work Order ID 52448

Friday, September 25, 2009 10:59:40 AM

Page 3

Item ID: D3110-1

Accept

Revision ID: C

Item Name: Escutcheon

Start Date: 9/25/2009 Start Qty: 4.00

Required Date: 10/5/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/14

R 09-12-11

Picklist Print

Friday, September 25, 2009 10:59:40 AM

Work Order ID: 52448



Parent Item: D3110-1RevC



Parent Item Name: Escutcheon

Start Date: 9/25/2009

Required Date: 10/5/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.250X01.25 0		Purchased	No			100	f	80.3700	1.3600			



6061-T6 Bar .250 X 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

80.37

109058

20

→ 109140

40

10956

20.37

2.72" *aml 09/10/11*

DART AEROSPACE LTD		Work Order: 52448
Description: ESCUTCHEON		Part Number: D3110-1
Inspection Dwg: D3110 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.220	+/- .010	1.220	✓			
0.218	+/- .010	0.219	✓			
Ø 0.630	+0.005/-0.001	Ø 0.630	✓			
1.220	+/- .010	1.220	✓			
Ø 0.170	+0.005/-0.000	Ø 0.173	✓			
CSINK Ø0.320x100	+/- .010	0.321	✓			
2.124	+/- .010	2.123	✓			
1.062	+/- .010	1.061	✓			
0.12	+/- .030	0.120	✓			
0.025	+/- .010	0.028	✓			
R0.13	+/- .030	R0.125	✓			
R0.38	+/- .030	R0.380	✓			
2.878	+/- .010	2.879	✓			
60°	+/- 1/2°	60°	✓			

Measured by: G.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/10/11	Date: 09/10/11	Date:	N/A

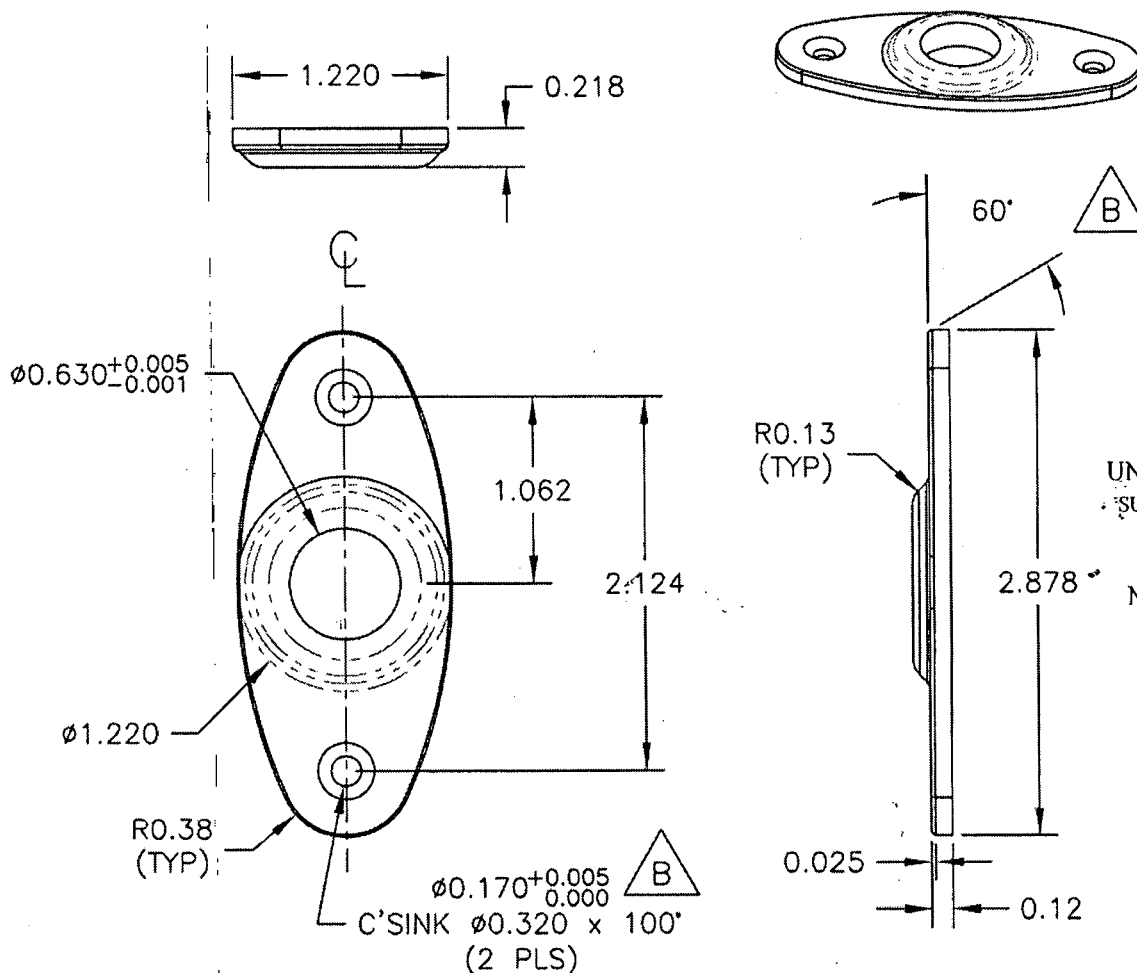
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3110	REV. C SHEET 1 OF 3
DATE 05.12.14		TITLE HANDLE	SCALE 1:1
A	02.04.11	NEW ISSUE	
B	04.10.18	ADD PART MARKING, TOLERANCES	
C	05.12.14	REVISE D3110-5	

RELEASED

05.12.15



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52448

D3110-1 ESCUTCHEON**NOTES:**

- 1) MATERIAL: 6061-T6 BAR (QQ-A-200/8 OR QQ-A-225/8) 0.250 THICK (M6061T6B)
- 2) FINISH: POLISHED
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) REPLACES ADAMS RITE P/N AR75
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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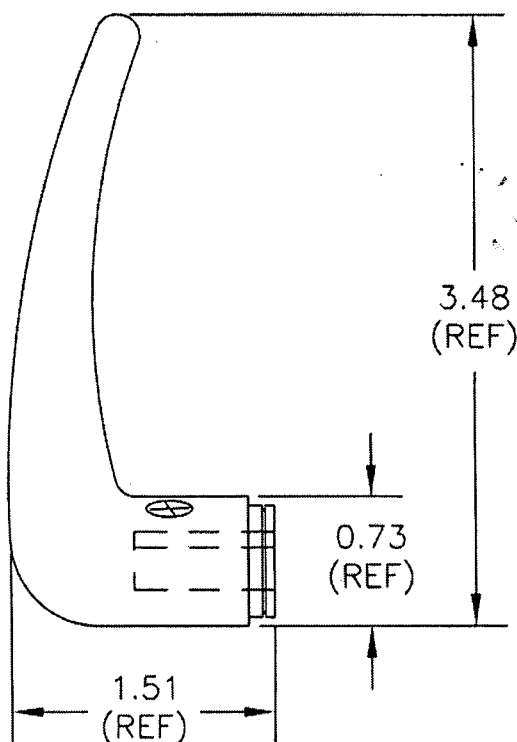


W/O 52445

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3110	REV. C SHEET 2 OF 3
DATE 05.12.14		TITLE HANDLE	SCALE 1:1

RELEASED

05.12.15 #



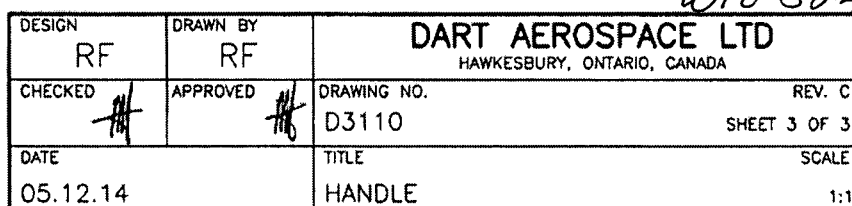
D3110-3 HANDLE

NOTES:

- 1) POSSIBLE SUPPLIERS: ADAMS RITE P/N AR34
BELL P/N 70-027-1
PREMIER P/N 034-23002-01
- 2) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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RELEASED
05.12.15

4.15 (REF)

4.70 (REF)

0.125

0.575

1.05 (REF)

1.05 (REF)

1.42 (REF)

1.96 (REF)

R0.032

C 4

C 4

D3110-5 HANDLE

NOTES:

- 1) POSSIBLE SUPPLIER: ADAMS RITE P/N 4298
- 2) IDENTIFY WITH PART P/N USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) MODIFY STEM AS SHOWN
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Work Order Summary

December 2, 2009 9:28:03 AM

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Criteria : Work Order ID: 52448 Item ID: D3110-1RevC Product Family MACHINING
Work Order Start Dates 9/25/09 to 9/25/09 11:59:59 PM Work Order Required Dates 10/05/09 to 10/05/09 11:59:59 PM

All References

Work Order Status Released

Work Order ID 52448 Required Qty 4.0000 Status Code Released
Item ID D3110-1RevC Accepted Qty 0.0000 Scrap Qty 0.0000
Item Name Escutcheon
Current Acct Value \$70.113 Sales Order ID

Start Date 9/25/09 Required Date 10/05/09 Completed Date
Standard ** Actual ** ** Acct. Value ** ** Variance ** ** Variance % **

Direct Costs	Total	Each	Each	Each	Each
Material	\$2.821	\$0.000	\$0.353	\$0.353	100.00%
Labor	\$97.061	\$0.000	\$21.420	\$21.420	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$216.724	\$0.000	\$48.340	\$48.340	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$316.606	\$0.000	\$70.113	\$70.113	

Item ID/ Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M6061T6B0.250X01.250	1.3600				
6061-T6 Bar .250 X 1.25			10/11/09	2.7200	\$2.821
Total Matl Amts:					\$2.821

Work Center HAAS I

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
AUCL01		10/11/09										
110			0.00	0.00	5.50	5.50	1.00	\$0.000	\$97.061	\$216.724	\$0.000	\$313.78
Total:			0.00	0.00	5.50	5.50	1.00	\$0.000	\$97.061	\$216.724	\$0.000	\$313.78

REFERENCE ONLY

speeds in when approx please